



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-145
Job Sheet 168919-A



Part No: D205-634-145

Job Qty: 1 ea

Part Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/24/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Sequoia Helicopters Ltd (CSEQU01)

30750 Threshold Drive Abbotsford, BC, V2T 6H5 Canada ph:(604) 852-1704

Note: DWG D2580-049 REV H, IIN-D205-634 REV I IPP REV:B 14.04.21 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Skidtubes		
110	Skidtubes	1 pcs	1/11/18	1/11/18	0.00	2.01	Skidtubes		
120	CNC Bend Skidtubes	1 pcs	1/11/18	1/11/18	0.49	0.60	CNC Bend Skidtube		
130	Skidtubes	1 pcs	1/11/18	1/11/18	0.00	2.01	Skidtubes		
140	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC5		
150	Skidtubes	1 pcs	1/11/18	1/11/18	0.00	2.01	Skidtubes		
160	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC10		
170	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC5		
180	HandFinish	1 pcs	1/11/18	1/11/18	0.00	1.07	HandFinish2		
190	Powdercoat	1 pcs	1/11/18	1/11/18	0.00	0.18	Powdercoat1		
200	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC3		
210	HandFinish	1 pcs	1/12/18	1/12/18	0.00	1.07	HandFinish4		
220	QC	1 pcs	1/12/18	1/12/18	0.00	0.00	QC5		
225	DC	1 pcs	1/12/18	1/12/18	0.00	0.00	DC		
230	Packaging	1 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3		
240	QC21-FG	1 Ea	1/12/18	1/12/18	0.00	0.00	QC21		

Part Op 110 - 1- PICK D2580-1

Descriptions: 120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required.

180 - And realodine tube as per QSI 005

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

230 - Identify and pack for shipping as per PPPD205-634-145 Location : FG073

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2580-1 5014926	1	12	0	0
210-HandFinish	AN3-5A 5013737	2	216	0	0
	AN4-45A 5038734	8	31	0	0
	D2570 5030004	16	196	0	0

5038288 x RH

000672

DART
AEROSPACE
S038288

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



**Replacement Skidtube with Thru – Bolt Standard Wearplates
Fits LH or RH**

PART NO: D205 – 634 – 145

Original Serial #: S038288

Revision:

Operation: CNC Bend Skidtube 02/02/18

Change No: CHG001

Job No: 168919 – A

D2576-3	F151399	1	66	0	0
D2594-1	5025442	8	265	0	0
D2594-3	F150210	8	282	0	0
D2855	F151613	1	84	0	0
D4202-1	5030798	24	179	0	0
D5061-1	5019473	1	1	0	0
D5061-3	5023925	1	1	0	0
MS21042-4	5038763	8	3	0	0
NAS1149D0332J	5020606	2	1,792	0	0

Part Specifications

Specifications could not be found.

Plex 11/24/17 3:24 PM dart.poulin.mario

ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2580-1-180	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2584-1	PLUG
25	16	16	8	8	D2584-3	O-RING
26	1	1	1	1	D2598	205 WEB
27	1	1	1	1	D2585	AFT CAP
28	1	1			D3584-5	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1	1	D4405-041	WEARPLATE ASSEMBLY
34			1	1	D4405-043	WEARPLATE ASSEMBLY
35				1	D5081-1	FINO WEARPLATE
36				1	D5081-3	AFT WEARPLATE
50	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AELS-1032-130	INSERT
51	50	50			ANS4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-40A	BOLT
54	50	50			NAS1146C0332R	WASHER (AN80C10L)
55	2	2	2	2	NAS1146D0332J	WASHER (AN80D10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

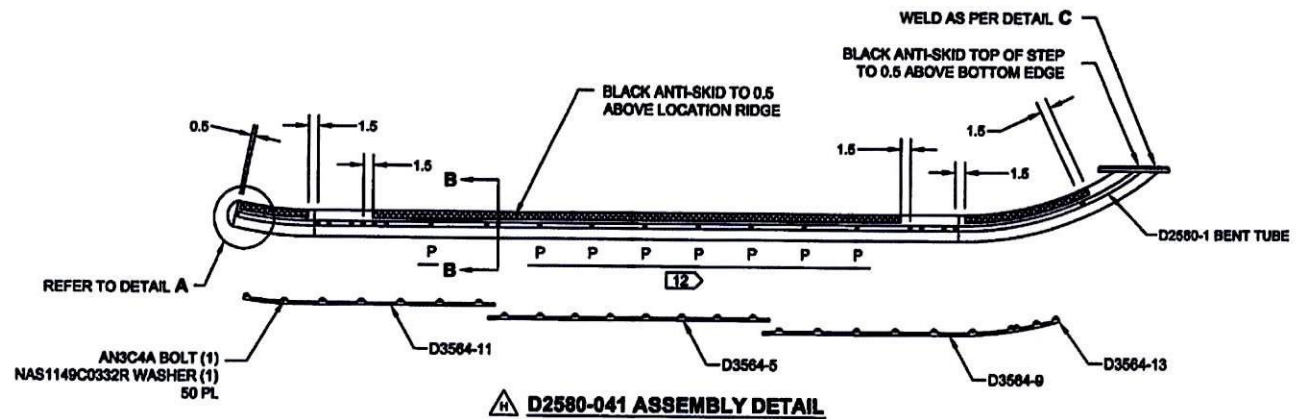
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2580 WEB POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 46.1 lbs
D2580-047 = 32.0 lbs
D2580-048 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2580 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8637 ONLY FOR D2580-041/045 TO LOCATE AND DRILL 20.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (60 PLACES) AFTER FINISH. INSTALL AN54A BOLTS AND NAS1146C0332R WASHERS WITH SIKAFLEX-241-281.
- 12) INSERT D2584-1 PLUG C/W D2584-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/045 AND 8 PLACES FOR D2580-047/049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2585 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

H	SHEET: PL DELETE D3580-1/5-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 8588	AJS	14.04.09
F	INCORPORATE DED D2580-E-1 PER PART12-218	DC	13.06.20
E	ADD D2580-047 (ZN CA-7) AND D2580-7 (ZN B3-9); INCLUDED DED D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8637 WAS TD2577-205 (ZN CA-1)	RF	11.06.21
D	CHANGE TO 85 WEARPLATES AND GASKETS, INCLUDE DED 8124/0183	PH	07.04.06
C	REDRAWN, INCLUDED DED 9094/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	D2580		
APPROVED	TITLE		
DE APPR.	205 SKIDTUBE ASSEMBLY		
DATE	17.06.09		
	SCALE		
	REV. H		
	SHEET 1 OF 9		
	NTS		

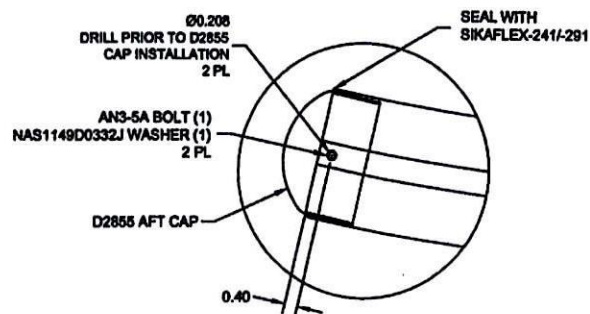
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HAWKESBURY, ONTARIO, CANADA

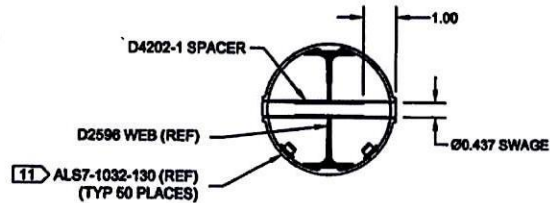
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DETAIL A
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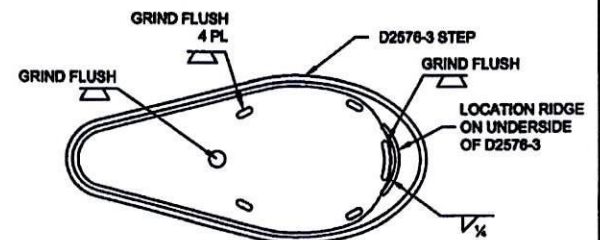


SECTION B-B
SCALE 5X



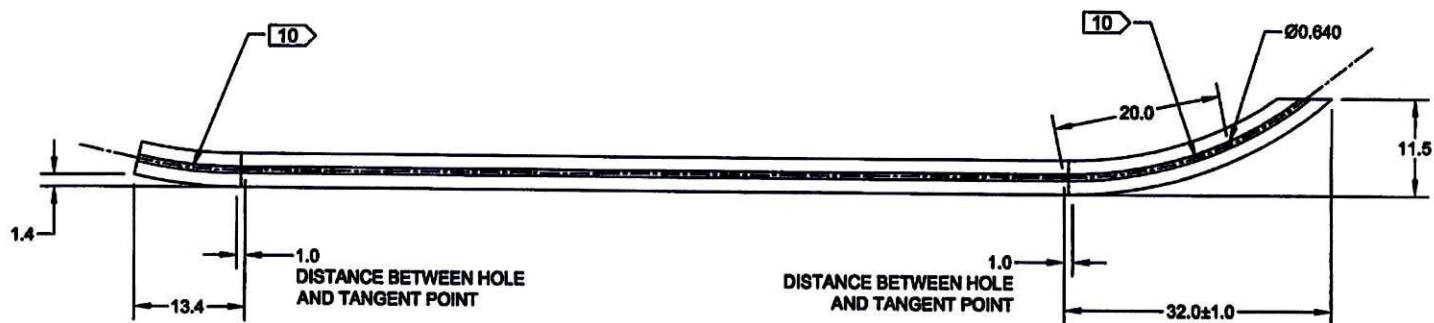
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X



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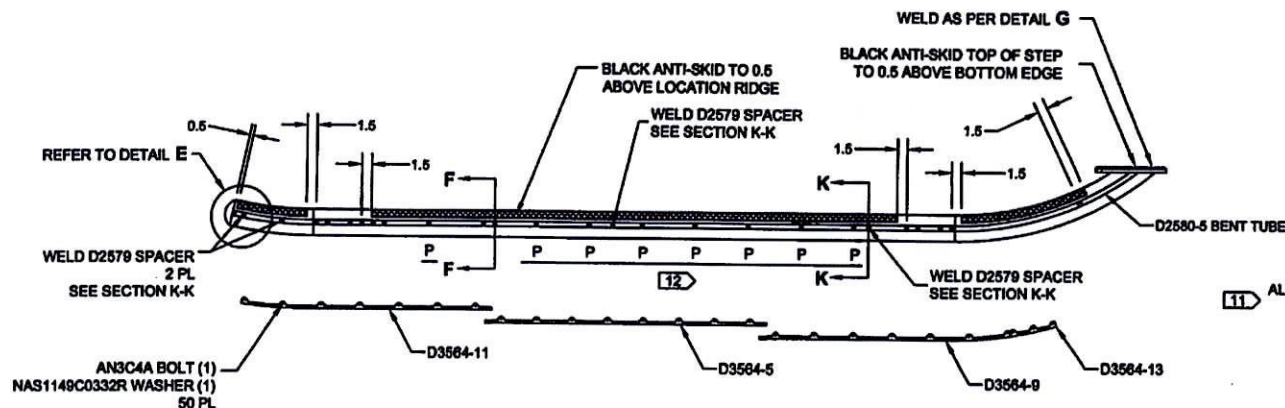
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

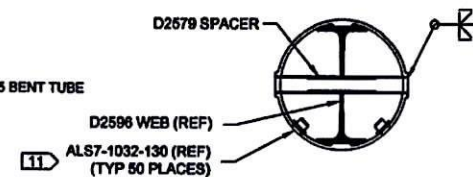
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 9
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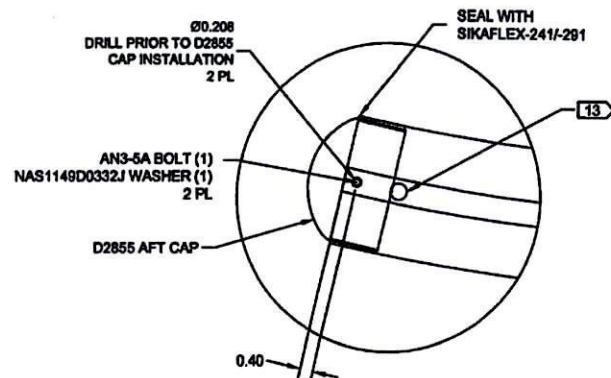
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
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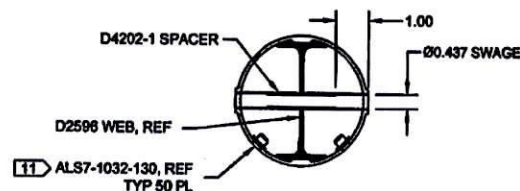


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

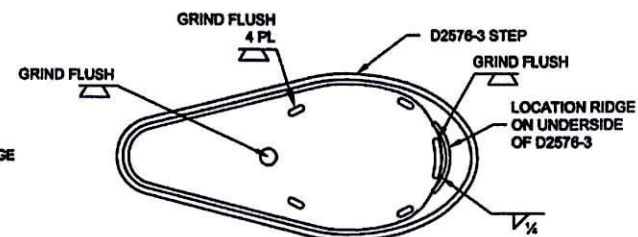


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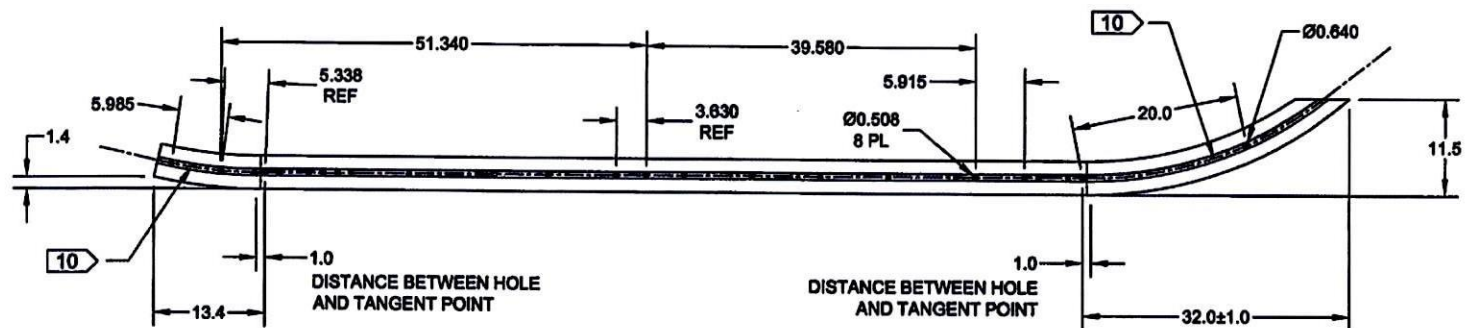
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



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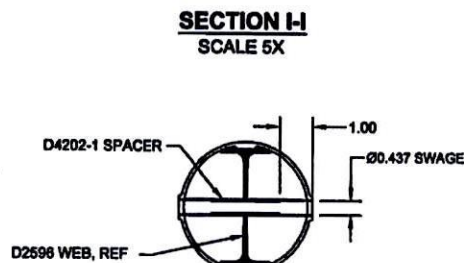
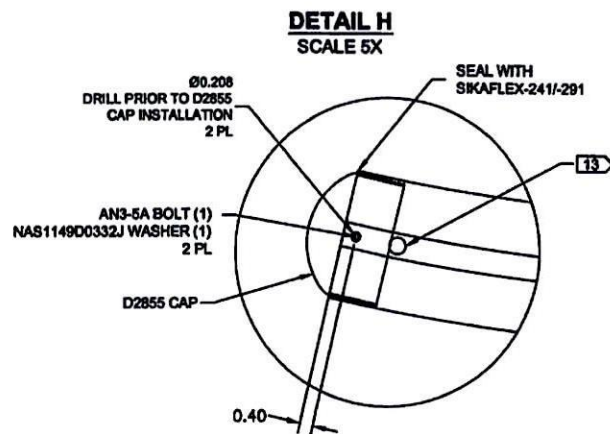
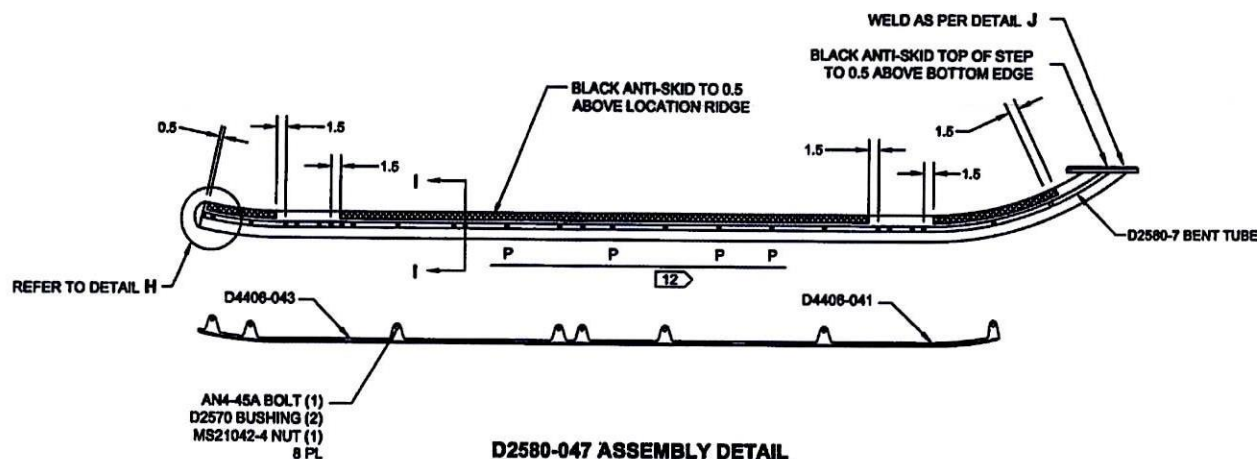


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

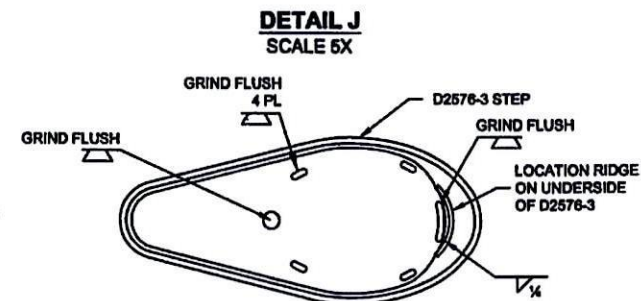
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 5 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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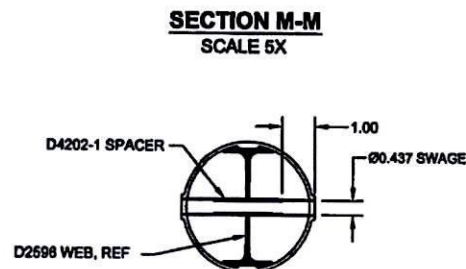
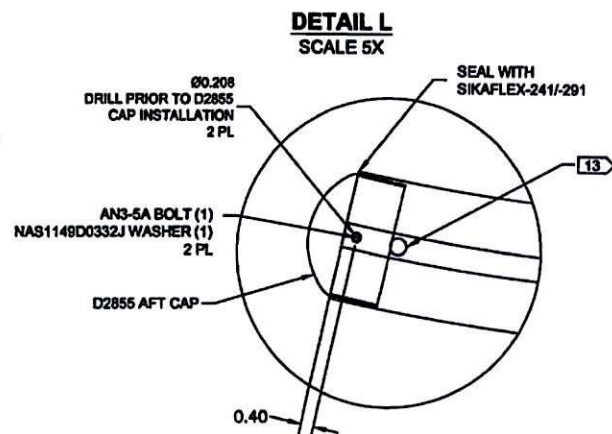
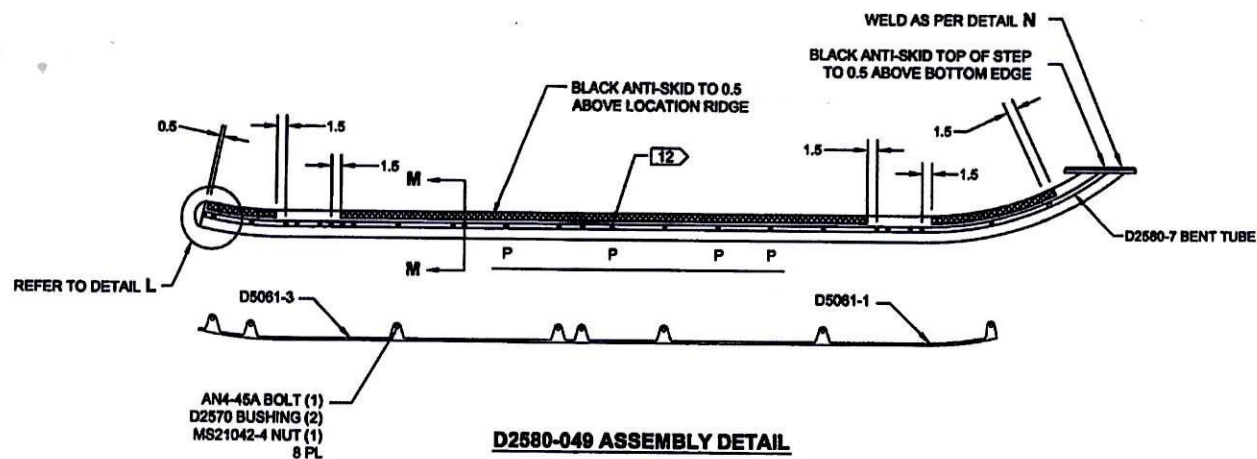
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



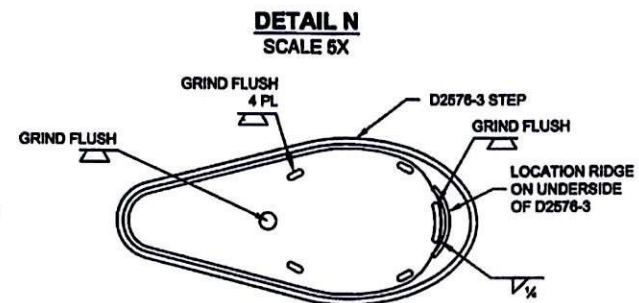
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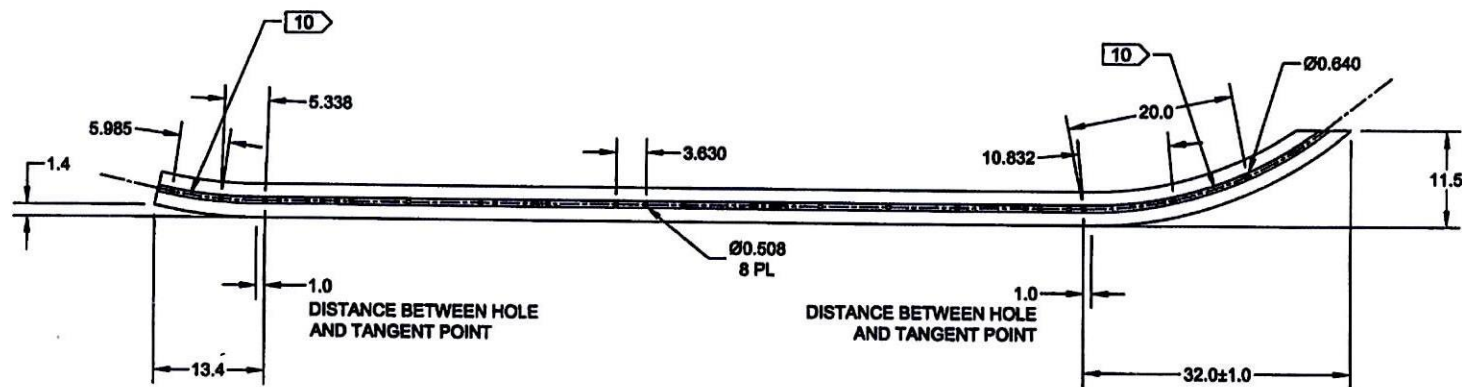


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
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2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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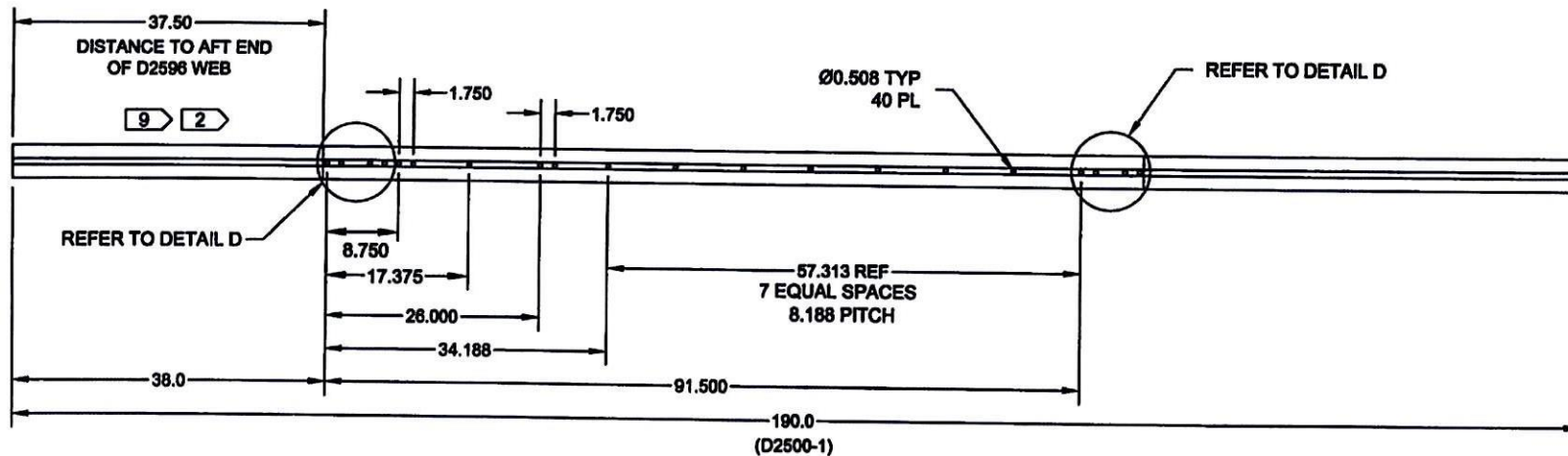
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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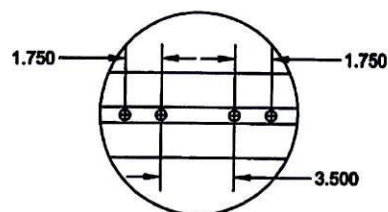
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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DATE	17.06.09		



D2580-101 TUBE



DETAIL D
SCALE 5X

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DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 9 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1